DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-015059
Date Inspected: 21-Jun-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 645
OSM Departure Time: 1845
Location: Shanghai, China

CWI Name:				**CWI Present:**	☐ Yes	☑ No		
Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**Rod Oven in Use:**	☐ Yes	☐ No	☑ N/A	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A	
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A	
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Approved WPS:**	☑ Yes	☐ No	☐ N/A	
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A	

Bridge No: 34-0006
Component: Orthotropic Box Girder(OBG)

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance (QA) Inspector Amit Juvekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

Subassembly, Bay 04, Deck Panel 13CW-DP3149-001.

This QA inspector performed conventional Ultrasonic Testing (UT) Inspection on deck panel tack weld areas. The inspection is preliminary prior to using the phased array (PAUT) testing system to verify indications found with conventional Ultrasonic testing. QA inspector performed UT on deck panel DP3149-001, 09 ribs, 18 welds, 138 total tack welds inspected.

Weld 138 scanned 9 locations with no indication.
Weld 139 scanned 9 locations with 1 indications.
Weld 173 scanned 9 locations with no indications.
Weld 174 scanned 9 locations with no indication.
Weld 140 scanned 9 locations with 1 indications.
Weld 141 scanned 9 locations with no indications.
Weld 176 scanned 5 locations with no indications.
Weld 177 scanned 5 locations with no indications.
Weld 178 scanned 5 locations with no indications.
Weld 180 scanned 5 locations with no indications.

Weld 179 scanned 5 locations with no indications.
Weld 181 scanned 5 locations with noindications.

Subassembly, Bay 09, 13CE, Continuity Stiffener inside U-Rib.

FCAW welding of weld complete penetration joint DP3101-001-275, 276, 277, 278, 279, 280; located on subassembly, Bay 09, 13BE. Welder is identified as 062259; ZPMC Quality Control Inspector (QC) is identified as Chen Shin gang . The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2233-TC-U4B-F.

Subassembly, Bay 09, 13BE, Continuity Stiffener inside U-Rib.

FCAW welding of Fillet weld joint DP3104-001-266267, 268, 269; located on subassembly, Bay 09, 13BE. Welder is identified as 062259; ZPMC Quality Control Inspector (QC) is identified as Chen Shin gang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2133.

Subassembly, Bay 09, 13CE, Continuity Stiffener inside U-Rib.

FCAW welding of weld complete penetration joint DP3101-001-192, 200; located on subassembly, Bay 09, 13BE. Welder is identified as 062259; ZPMC Quality Control Inspector (QC) is identified as Chen Shin gang . The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2233-TC-U4B-F.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 1500.042.2372, who represents the Office of Structural Materials for your project.

Inspected By:	Juvekar,Amit	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer